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**D206-642-241**  
**Job Sheet 195712**



**Part No:** D206-642-241

**Job Qty:** 1 pcs

**Part Name:** Replacement Skidtube, High Gear with Standard Wearplates Fits LH or RH



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 5/30/19

**Job Tracking No:**

**Due Date:** 7/5/19

**Created By:** Kimberley Guerin

**Type:** Stock

**Description:**

**Note:** DWG REV F(DEO) IPP Rev: 04.12.02 Revised procedural steps KJ/JLM IPP RevP: revise and update route/bom DD 10.01.06 verf:EC IPP rev Q 10.02.19 per PAR 09-043 EC verified by: DD IPP Rev:R 12.11.22 now swage per ecn12-679 DD verf:JLM IPP Rev:S 14.04.24 ECN14-520 DD verf:JLM

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation     | Qty      | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off    |
|-------|---------------|----------|------------|----------|-----------|---------|-----------------------|-----------|-------------|
|       |               |          |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |             |
| 110   | Skidtubes - 1 | 1<br>pcs |            | 7/5/19   | 0.00      | 2.22    | Skidtubes - 1         |           | DO          |
|       |               |          |            |          |           |         | Skidtubes - 2         |           |             |
|       |               |          |            |          |           |         | Skidtubes - 3         |           |             |
|       |               |          |            |          |           |         | Skidtubes - 4         |           |             |
|       |               |          |            |          |           |         | Skidtubes - 5         |           |             |
|       |               |          |            |          |           |         | Skidtubes - 6         |           |             |
|       |               |          |            |          |           |         | Skidtubes - 7         |           |             |
| 120   | QC 5          | 1<br>pcs |            | 7/5/19   | 0.00      | 0.00    | QC 5 - 10             |           | JUN 20 2019 |
|       |               |          |            |          |           |         | QC 5 - 12             |           |             |
|       |               |          |            |          |           |         | QC 5 - 17             |           |             |
|       |               |          |            |          |           |         | QC 5 - 18             |           |             |
|       |               |          |            |          |           |         | QC 5 - 19             |           |             |
|       |               |          |            |          |           |         | QC 5 - 22             |           |             |
|       |               |          |            |          |           |         | QC 5 - 24             |           |             |
|       |               |          |            |          |           |         | QC 5 - 3              |           |             |
|       |               |          |            |          |           |         | QC 5 - 43             |           |             |
|       |               |          |            |          |           |         | QC 5 - 49             |           |             |
|       |               |          |            |          |           |         | QC 5 - 51             |           |             |
|       |               |          |            |          |           |         | QC 5 - 58             |           |             |
|       |               |          |            |          |           |         | QC 5 - 68             |           |             |
|       |               |          |            |          |           |         | QC 5 - 9              |           |             |
|       |               |          |            |          |           |         | QC 5 - 50             |           |             |
|       |               |          |            |          |           |         | QC 5 - 30             |           |             |
|       |               |          |            |          |           |         | QC 5 - 40             |           |             |
|       |               |          |            |          |           |         | QC 9 - 11             |           |             |
|       |               |          |            |          |           |         | QC 9 - 18             |           |             |
|       |               |          |            |          |           |         | QC 9 - 24             |           |             |
|       |               |          |            |          |           |         | QC 9 - 43             |           |             |
|       |               |          |            |          |           |         | QC 9 - 50             |           |             |
|       |               |          |            |          |           |         | QC 9 - 9              |           |             |
| 130   | QC 9          | 1<br>pcs |            | 7/5/19   | 0.00      | 0.00    | QC 9 - 11             |           | JUN 20 2019 |
|       |               |          |            |          |           |         | QC 9 - 18             |           |             |
|       |               |          |            |          |           |         | QC 9 - 24             |           |             |
|       |               |          |            |          |           |         | QC 9 - 43             |           |             |
|       |               |          |            |          |           |         | QC 9 - 50             |           |             |
|       |               |          |            |          |           |         | QC 9 - 9              |           |             |

Plex 5/30/19 9:06 AM Dart, Guerin, Kimberley

140 Handfinish - 1-1 Chemical- B4B 1  
pcs

7/5/19 0.00 0.33 Handfinish - 1 - 1 - B4B

Handfinish - 1 - 2 - B4B

Handfinish - 1 - 3 - B4B

Handfinish - 1 - 4 - B4B

Handfinish - 1 - 5 - B4B

Handfinish - 1 - 6 - B4B

Handfinish - 1 - 7 - B4B

Handfinish - 1 - 8 - B4B

Handfinish - 1 - 9 - B4B

Handfinish - 1 - 10 -  
B4BHandfinish - 1 - 11 -  
B4BHandfinish - 1 - 12 -  
B4BHandfinish - 1 - 13 -  
B4BHandfinish - 1 - 14 -  
B4BHandfinish - 1 - 15 -  
B4BHandfinish - 1 - 16 -  
B4BHandfinish - 1 - 17 -  
B4BHandfinish - 1 - 18 -  
B4BHandfinish - 1 - 19 -  
B4BHandfinish - 1 - 20 -  
B4BHandfinish - 1 - 21 -  
B4BHandfinish - 1 - 22 -  
B4B

JUN 25 2019

150 QC 7

1  
pcs

7/5/19 0.00 0.00

QC 7 - 10

QC 7 - 13

QC 7 - 14

QC 7 - 15

QC 7 - 17

QC 7 - 18

QC 7 - 19

QC 7 - 2

QC 7 - 28

QC 7 - 3

QC 7 - 30

QC 7 - 34

QC 7 - 36

QC 7 - 37

QC 7 - 41

QC 7 - 47

QC 7 - 48

QC 7 - 51

QC 7 - 58

QC 7 - 59

QC 7 - 60

QC 7 - 9

QC 7 - 68

QC 7 - 50

QC 7 - 67

QC 7 - 40

BE

|                         |          |        |           |                     |    |
|-------------------------|----------|--------|-----------|---------------------|----|
| 160 Skidtubes - 2 - B4B | 1<br>pcs | 7/5/19 | 0.00 2.50 | QC 7 - 24           |    |
|                         |          |        |           | QC 7 - 43           |    |
|                         |          |        |           | Skidtubes - 1 - B4B | 00 |
|                         |          |        |           | Skidtubes - 2 - B4B |    |
|                         |          |        |           | Skidtubes - 3 - B4B |    |
|                         |          |        |           | Skidtubes - 4 - B4B |    |
|                         |          |        |           | Skidtubes - 5 - B4B |    |
|                         |          |        |           | Skidtubes - 6 - B4B |    |
| 180 Skidtubes - 3 - B4B | 1<br>pcs | 7/5/19 | 0.00 2.50 | Skidtubes - 7 - B4B |    |
|                         |          |        |           | Skidtubes - 1 - B4B | 00 |
|                         |          |        |           | Skidtubes - 2 - B4B |    |
|                         |          |        |           | Skidtubes - 3 - B4B |    |
|                         |          |        |           | Skidtubes - 4 - B4B |    |
|                         |          |        |           | Skidtubes - 5 - B4B |    |
|                         |          |        |           | Skidtubes - 6 - B4B |    |
|                         |          |        |           | Skidtubes - 7 - B4B |    |
| 190 QC 5                | 1<br>pcs | 7/5/19 | 0.00 0.00 | QC 5 - 10           |    |
|                         |          |        |           | QC 5 - 12           |    |
|                         |          |        |           | QC 5 - 17           |    |
|                         |          |        |           | QC 5 - 18           | BE |
|                         |          |        |           | QC 5 - 19           |    |
|                         |          |        |           | QC 5 - 22           |    |
|                         |          |        |           | QC 5 - 24           |    |
|                         |          |        |           | QC 5 - 3            |    |
|                         |          |        |           | QC 5 - 43           |    |
|                         |          |        |           | QC 5 - 49           |    |
|                         |          |        |           | QC 5 - 51           |    |
|                         |          |        |           | QC 5 - 58           |    |
|                         |          |        |           | QC 5 - 68           |    |
|                         |          |        |           | QC 5 - 9            |    |
|                         |          |        |           | QC 5 - 50           |    |
|                         |          |        |           | QC 5 - 30           |    |
|                         |          |        |           | QC 5 - 40           |    |
| 200 Skidtubes - 4 - B4B | 1<br>pcs | 7/5/19 | 0.00 2.50 | Skidtubes - 1 - B4B | 00 |
|                         |          |        |           | Skidtubes - 2 - B4B |    |
|                         |          |        |           | Skidtubes - 3 - B4B |    |
|                         |          |        |           | Skidtubes - 4 - B4B |    |
|                         |          |        |           | Skidtubes - 5 - B4B | BE |
|                         |          |        |           | Skidtubes - 6 - B4B |    |
|                         |          |        |           | Skidtubes - 7 - B4B |    |
| 220 QC 9                | 1<br>pcs | 7/5/19 | 0.00 0.00 | QC 9 - 10           |    |
|                         |          |        |           | QC 9 - 18           |    |
|                         |          |        |           | QC 9 - 24           |    |
|                         |          |        |           | QC 9 - 43           |    |
|                         |          |        |           | QC 9 - 50           |    |
|                         |          |        |           | QC 9 - 9            |    |
|                         |          |        |           | QC 5 - 10           |    |
| 230 QC 5                | 1<br>pcs | 7/5/19 | 0.00 0.00 | QC 5 - 12           |    |
|                         |          |        |           | QC 5 - 17           |    |
|                         |          |        |           | QC 5 - 18           |    |
|                         |          |        |           | QC 5 - 19           |    |
|                         |          |        |           | QC 5 - 22           |    |
|                         |          |        |           | QC 5 - 24           |    |
|                         |          |        |           | QC 5 - 3            |    |
|                         |          |        |           | QC 5 - 43           |    |
|                         |          |        |           | QC 5 - 49           |    |
|                         |          |        |           | QC 5 - 51           |    |
|                         |          |        |           | QC 5 - 58           |    |
|                         |          |        |           | QC 5 - 68           |    |

|                                        |          |        |           |                          |  |
|----------------------------------------|----------|--------|-----------|--------------------------|--|
| 240 Handfinish - 2-1 Pressure- B4B     | 1<br>pcs | 7/5/19 | 0.00 0.33 | QC 5 - 9                 |  |
|                                        |          |        |           | QC 5 - 50                |  |
|                                        |          |        |           | QC 5 - 30                |  |
|                                        |          |        |           | QC 5 - 40                |  |
|                                        |          |        |           | Handfinish - 2 - 1 - B4B |  |
| 250 Powdercoat - 1 White Gl(A)-<br>B4B | 1<br>pcs | 7/5/19 | 0.00 0.28 | Handfinish - 2 - 2 - B4B |  |
|                                        |          |        |           | Handfinish - 2 - 3 - B4B |  |
|                                        |          |        |           | Handfinish - 2 - 4 - B4B |  |
|                                        |          |        |           | Powdercoat - 1 - B4B     |  |
|                                        |          |        |           | Powdercoat - 2 - B4B     |  |
| 260 QC 3                               | 1<br>pcs | 7/5/19 | 0.00 0.00 | Powdercoat - 3 - B4B     |  |
|                                        |          |        |           | Powdercoat - 4 - B4B     |  |
|                                        |          |        |           | QC 3 - 10                |  |
|                                        |          |        |           | QC 3 - 13                |  |
|                                        |          |        |           | QC 3 - 15                |  |
| 270 Handfinish - 3-1- WingWalk-<br>B4B | 1<br>pcs | 7/5/19 | 0.00 1.06 | QC 3 - 17                |  |
|                                        |          |        |           | QC 3 - 18                |  |
|                                        |          |        |           | QC 3 - 2                 |  |
|                                        |          |        |           | QC 3 - 28                |  |
|                                        |          |        |           | QC 3 - 3                 |  |
| 300 QC 5                               | 1<br>pcs | 7/5/19 | 0.00 0.00 | QC 3 - 30                |  |
|                                        |          |        |           | QC 3 - 34                |  |
|                                        |          |        |           | QC 3 - 36                |  |
|                                        |          |        |           | QC 3 - 41                |  |
|                                        |          |        |           | QC 3 - 51                |  |
| 310 Packaging 3-1 - Stock - B4B        | 1<br>pcs | 7/5/19 | 0.00 0.00 | QC 3 - 58                |  |
|                                        |          |        |           | QC 3 - 59                |  |
|                                        |          |        |           | QC 3 - 68                |  |
|                                        |          |        |           | QC 3 - 9                 |  |
|                                        |          |        |           | QC 3 - 40                |  |
|                                        |          |        |           | QC 3 - 19                |  |
|                                        |          |        |           | QC 3 - 43                |  |
|                                        |          |        |           | QC 3 - 24                |  |
|                                        |          |        |           | Handfinish - 3 - 1 - B4B |  |
|                                        |          |        |           | Handfinish - 3 - 2 - B4B |  |
|                                        |          |        |           | Handfinish - 3 - 3 - B4B |  |
|                                        |          |        |           | Handfinish - 3 - 4 - B4B |  |
|                                        |          |        |           | Handfinish - 3 - 5 - B4B |  |
|                                        |          |        |           | QC 5 - 10                |  |
|                                        |          |        |           | QC 5 - 12                |  |
|                                        |          |        |           | QC 5 - 17                |  |
|                                        |          |        |           | QC 5 - 18                |  |
|                                        |          |        |           | QC 5 - 19                |  |
|                                        |          |        |           | QC 5 - 22                |  |
|                                        |          |        |           | QC 5 - 24                |  |
|                                        |          |        |           | QC 5 - 3                 |  |
|                                        |          |        |           | QC 5 - 43                |  |
|                                        |          |        |           | QC 5 - 49                |  |
|                                        |          |        |           | QC 5 - 51                |  |
|                                        |          |        |           | QC 5 - 58                |  |
|                                        |          |        |           | QC 5 - 68                |  |
|                                        |          |        |           | QC 5 - 9                 |  |
|                                        |          |        |           | QC 5 - 50                |  |
|                                        |          |        |           | QC 5 - 30                |  |
|                                        |          |        |           | QC 5 - 40                |  |
|                                        |          |        |           | Packaging 3 - 1 - B4B    |  |
|                                        |          |        |           | Packaging 3 - 2 - B4B    |  |
|                                        |          |        |           | Packaging 3 - 3 - B4B    |  |
|                                        |          |        |           | Packaging 3 - 4 - B4B    |  |
|                                        |          |        |           |                          |  |

JUL 22 2019 40  
14-7-25

19-7-23

19-7-25

19-9-9

SEP 10 2019 40  
9-99

DAS  
15  
9-99

|                  |       |        |           |                 |                        |    |
|------------------|-------|--------|-----------|-----------------|------------------------|----|
|                  |       |        |           |                 | Packaging 3 - 5 - B4B  | MD |
|                  |       |        |           |                 | Packaging 3 - 6 - B4B  |    |
|                  |       |        |           |                 | Packaging 3 - 7 - B4B  |    |
|                  |       |        |           |                 | Packaging 3 - 8 - B4B  |    |
|                  |       |        |           |                 | Packaging 3 - 9 - B4B  |    |
|                  |       |        |           |                 | Packaging 3 - 10 - B4B |    |
|                  |       |        |           |                 | Packaging 3 - 11 - B4B |    |
|                  |       |        |           |                 | Packaging 3 - 12 - B4B |    |
|                  |       |        |           |                 | Packaging 3 - 13 - B4B |    |
|                  |       |        |           |                 | Packaging 3 - 14 - B4B |    |
|                  |       |        |           |                 | Packaging 3 - 15 - B4B |    |
|                  |       |        |           |                 | Packaging 3 - 16 - B4B |    |
|                  |       |        |           |                 | Packaging 3 - 17 - B4B |    |
|                  |       |        |           |                 | Packaging 3 - 18 - B4B |    |
|                  |       |        |           |                 | Packaging 3 - 19 - B4B |    |
|                  |       |        |           |                 | Packaging 3 - 20 - B4B |    |
|                  |       |        |           |                 | Packaging 3 - 21 - B4B |    |
|                  |       |        |           |                 | Packaging 3 - 22 - B4B |    |
|                  |       |        |           |                 | Packaging 3 - 23 - B4B |    |
|                  |       |        |           |                 | Packaging 3 - 24 - B4B |    |
|                  |       |        |           |                 | Packaging 3 - 25 - B4B |    |
|                  |       |        |           |                 | Packaging 3 - 26 - B4B |    |
|                  |       |        |           |                 | Packaging 3 - 27 - B4B |    |
|                  |       |        |           |                 | Packaging 3 - 28 - B4B |    |
|                  |       |        |           |                 | Packaging 3 - 29 - B4B |    |
|                  |       |        |           |                 | Packaging 3 - 30 - B4B |    |
|                  |       |        |           |                 | Packaging 3 - 31 - B4B |    |
|                  |       |        |           |                 | Packaging 3 - 32 - B4B |    |
|                  |       |        |           |                 | Packaging 3 - 33 - B4B |    |
|                  |       |        |           |                 | Packaging 3 - 34 - B4B |    |
|                  |       |        |           |                 | Packaging 3 - 35 - B4B |    |
|                  |       |        |           |                 | Packaging 3 - 36 - B4B |    |
| 315 DC - 1 - B4B | 1 pcs | 7/5/19 | 0.00 0.00 | DC - 1 - B4B    |                        |    |
|                  |       |        |           | DC - 2 - B4B    |                        |    |
| 320 QC 21 - FG   | 1 pcs | 7/5/19 | 0.00 0.00 | QC 21 - FG - 21 |                        |    |
|                  |       |        |           | QC 21 - FG - 70 |                        |    |
|                  |       |        |           | QC 21 - FG - 53 |                        |    |

Part Op 110 - 1-Deburr Fwd edge of tube 2- Remove ridge on inside of Fwd edge of tube as per Dwg D2650 3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required. 4-Grind weld flush to cap on top surface only. 5-Cut Aft end as per dwg D2650 from front of tube and Deburr 6-Remove Inner Indexing ridge on Aft end of skid tube as per Dwg D2650 7-Open holes for Aft end cap as per Dwg D2650 with #30 Drill Bit using DT8025. 8-Drill pilot holes using Dt 8167. 9-Locate DT8732A from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732B & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732A & doubler leaving DT8732B for added support. 10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time. 11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads. 12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D2650 13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder 14-Remove Indexing edge using DT9779 as per Dwg D2650. Leave 0.070" wall minimum. 15-C'sink GHW rivet holes as per Dwg D2650 16-Open crossbolt holes to Ø0.375" 17-Drill pilot holes using DT8028-3, then open to Ø0.297" as per Dwg D2650. Open Aft cap hole #6. 18- Ream crossbolt spacer holes to 0.377". 19-

120 - (QC5- Inspect part completeness to step on W/O)

130 - (QC9- Inspect visual per QSI004- Fusion Welds)

150 - (QC7-Inspect Chemical Conversion Coat)

160 - 1- Open and c'sink one crossbolt spacer holes as per Dwg D2650 (DEO Detail B)(without cutting fluid) 2-Deburr and blow out all chips from inside the tube

180 - 1-Locate, install and rivet doublers as per Dwg D2650. Micro-shave rivets as required 2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

190 - (QC5- Inspect part completeness to step on W/O)

200 - 1-Remove alodine in one area per DEO detail B from around hole and prepare for welding 2-Prep per QSI 005 and insert one D2649 crossbolt spacer. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod. 3-Grind welds flush as per Dwg D2650. 4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D2650. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required. 5- Insert D4720-1 Spacer. Swage to 0.313" X 0.75" DP per QSI 002. Trim and grind flush per QSI 002



220 - (QC9- Inspect visual per QSI004- Fusion Welds)

230 - (QC5- Inspect part completeness to step on W/O)

240 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

250 - (White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum) Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs. START TIME: \_\_\_\_\_ FINISH TIME: \_\_\_\_\_

260 - (QC3- Inspect Part Finish)

270 - (Wing Walk as per dwg QSI005 4.4 Batch 5185117) 1- Install inserts &amp; wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate. 2-Install D2680-041 Nut Plate as per Dwg D2650

300 - (QC5- Inspect part completeness to step on W/O)

310 - (Identify as per dwg &amp; Stock Location: \_\_\_\_\_) Identify and pack for shipping as per PPP D206-642-241

315 - Photocopy bluefile &amp; type labels per PPP D206-642-241 CHG007

320 - (QC21- Final Inspection - Work Order Release)

## Job BOM

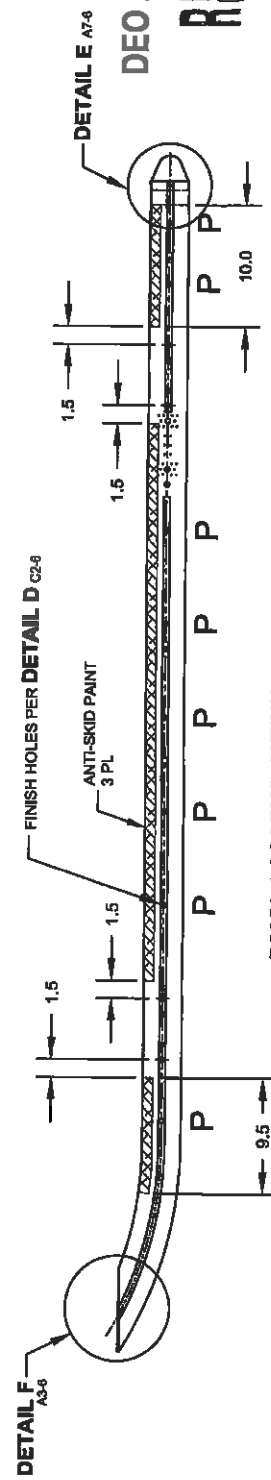
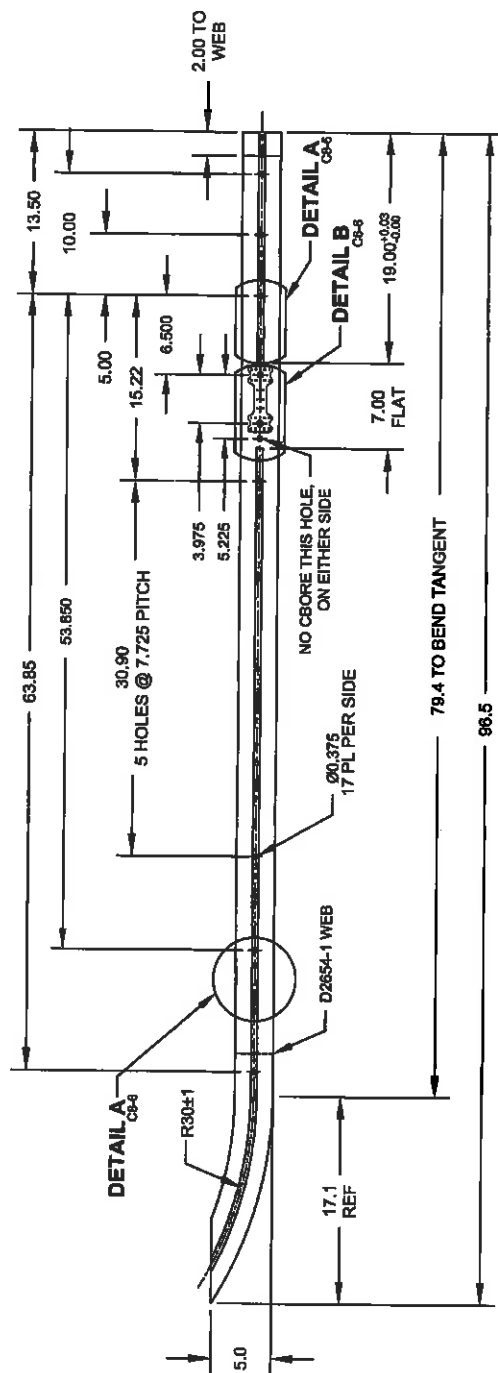
| Part / Item   | Component Name         | Quantity       | Operation                          | Container            |
|---------------|------------------------|----------------|------------------------------------|----------------------|
| D2620         | Skidtube, 206 Skidtube | 1 pcs (1 ea)   | 110-Skidtubes - 1                  | 5189522              |
| D2647         | Cap                    | 1 pcs (1 ea)   | 110-Skidtubes - 1                  | 5166098              |
| D3286-1       | Doubler                | 2 pcs (2 ea)   | 110-Skidtubes - 1                  | 5176117              |
| CR3212-4-04   | Cherry Rivet           | 52 Ea (52 ea)  | 180-Skidtubes - 3 - B4B            | 5161483x6 5171644x47 |
| D2654-3       | Web                    | 1 pcs (1 ea)   | 180-Skidtubes - 3 - B4B            | 5167121              |
| D2649         | Cross Bolt Spacer      | 1 pcs (1 ea)   | 200-Skidtubes - 4 - B4B            | 5136881              |
| D3286-3       | Spacer                 | 2 pcs (2 ea)   | 200-Skidtubes - 4 - B4B            | 5173052              |
| D4720-1       | Spacer                 | 17 pcs (17 ea) | 200-Skidtubes - 4 - B4B            | 5173039              |
| ALS4-1032-130 | Rivnut                 | 44 Ea (44 ea)  | 270-Handfinish - 3-1- WingWalk-B4B | 5057257              |
| D2646         | Aft Cap                | 1 pcs (1 ea)   | 270-Handfinish - 3-1- WingWalk-B4B | 5160607              |
| D2651-1       | Plug                   | 18 pcs (18 ea) | 270-Handfinish - 3-1- WingWalk-B4B | 5196044              |
| D2651-3       | O-Ring                 | 18 pcs (18 ea) | 270-Handfinish - 3-1- WingWalk-B4B | 5180320              |
| D2680-041     | Nut Plate              | 1 pcs (1 ea)   | 270-Handfinish - 3-1- WingWalk-B4B | 5197841              |
| D3537-1       | Wearpad                | 4 pcs (4 ea)   | 270-Handfinish - 3-1- WingWalk-B4B | 5195622              |
| D3537-3       | Wearpad                | 1 pcs (1 ea)   | 270-Handfinish - 3-1- WingWalk-B4B | 5183624              |
| D4956-13      | Wearplate Fwd          | 1 pcs (1 ea)   | 270-Handfinish - 3-1- WingWalk-B4B | 5178411              |
| D4956-21      | Wearplate Center       | 1 pcs (1 ea)   | 270-Handfinish - 3-1- WingWalk-B4B | 51706197             |
| D4956-33      | Wearplate Aft          | 1 pcs (1 ea)   | 270-Handfinish - 3-1- WingWalk-B4B | 51706151             |
| MS27039-1-08  | Screw 5180295 (226)    | 46 Ea (46 ea)  | 270-Handfinish - 3-1- WingWalk-B4B | 5162897 (220)        |
| MS27039-4-06  | Screw                  | 1 Ea (1 ea)    | 270-Handfinish - 3-1- WingWalk-B4B | 5166974 (11)         |
| NAS1149D0332J | Washer                 | 46 Ea (46 ea)  | 270-Handfinish - 3-1- WingWalk-B4B | 5178371              |
| NAS1149D0463J | Washer                 | 1 Ea (1 ea)    | 270-Handfinish - 3-1- WingWalk-B4B | 5058412              |
| CCR264SS3-3   | Cherry Rivet F4137627  | 2 Ea (2 ea)    | 270-Handfinish - 3-1- WingWalk-B4B | 5049573 (11)         |
| CR3212-4-03   | Cherry Rivet           | 2 Ea (2 ea)    | 270-Handfinish - 3-1- WingWalk-B4B | F41376286-D          |

| Job Allocations                    |                |          |           |           |
|------------------------------------|----------------|----------|-----------|-----------|
| Operation                          | Component Part | Required | Inventory | Allocated |
| 110-Skidtubes - 1                  | D2620          | 1        | 4         | 0         |
|                                    | D2647          | 1        | 43        | 0         |
|                                    | D3286-1        | 2        | 36        | 0         |
| 180-Skidtubes - 3 - B4B            | CR3212-4-04    | 52       | 631       | 0         |
|                                    | D2654-3        | 1        | 10        | 0         |
| 200-Skidtubes - 4 - B4B            | D2649          | 1        | 70        | 0         |
|                                    | D3286-3        | 2        | 24        | 0         |
|                                    | D4720-1        | 17       | 222       | 0         |
|                                    | ALS4-1032-130  | 44       | 7,594     | 0         |
| 270-Handfinish - 3-1- WingWalk-B4B | CCR264SS3-3    | 2        | 159       | 0         |
|                                    | CR3212-4-03    | 2        | 84        | 0         |
|                                    | D2646          | 1        | 33        | 0         |
|                                    | D2651-1        | 18       | 95        | 0         |
|                                    | D2651-3        | 18       | 304       | 0         |
|                                    | D2680-041      | 1        | 11        | 0         |
|                                    | D3537-1        | 4        | 68        | 0         |
|                                    | D3537-3        | 1        | 18        | 0         |
|                                    | D4956-13       | 1        | 5         | 0         |
|                                    | D4956-21       | 1        | 0         | 0         |
|                                    | D4956-33       | 1        | 2         | 0         |
|                                    | MS27039-1-08   | 46       | 467       | 0         |
|                                    | MS27039-4-06   | 1        | 95        | 0         |
|                                    | NAS1149D0332J  | 46       | 3,596     | 0         |
|                                    | NAS1149D0463J  | 1        | 3,447     | 0         |
| Part Specifications                |                |          |           |           |
| Specifications could not be found. |                |          |           |           |

Plex 5/30/19 9:06 AM Dart.Guerin.Kimberley



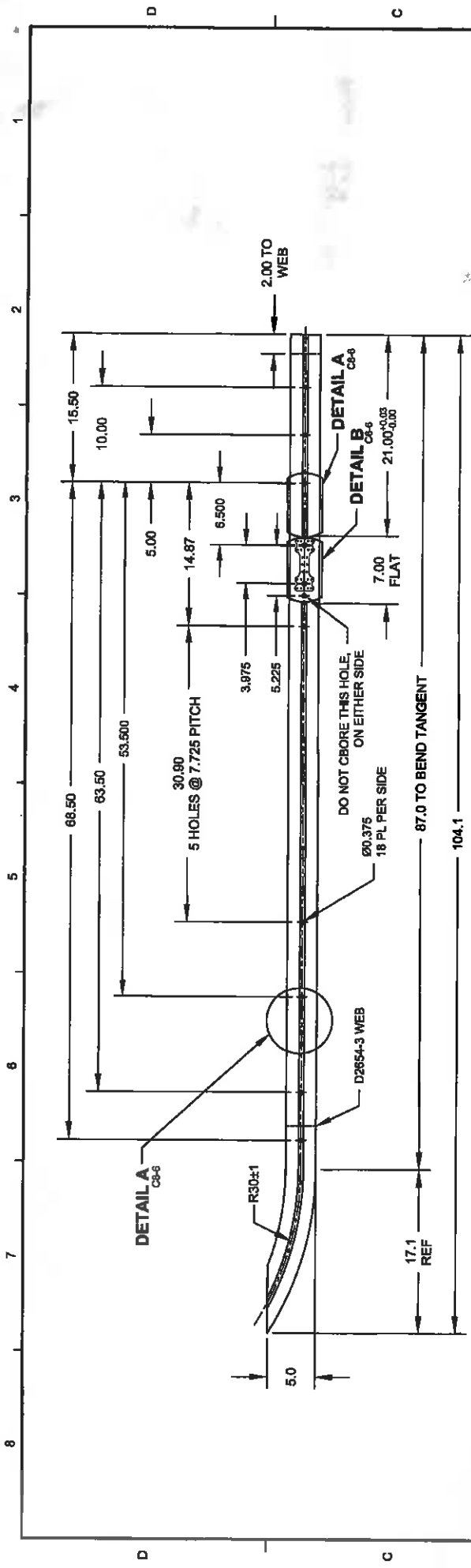




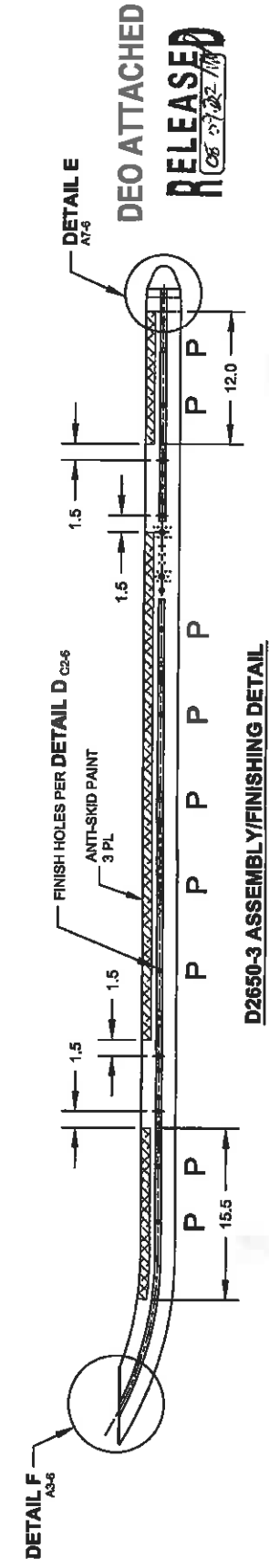
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|            |                    |                                             |              |
|------------|--------------------|---------------------------------------------|--------------|
| DESIGN     | DS                 | DART AEROSPACE USA, INC                     |              |
| DRAWN      | AJS                | PORT HADLOCK, WA                            |              |
| CHECKED    | <i>[Signature]</i> | DRAWING NO.                                 | REV. F       |
| MFG. APPR. | <i>[Signature]</i> | D2850                                       | SHEET 2 OF 6 |
| APPROVED   | <i>[Signature]</i> | TITLE                                       | SCALE        |
| DE APPR.   | <i>[Signature]</i> | 206/407 SKIDTUBE ASSEMBLIES                 | NTS          |
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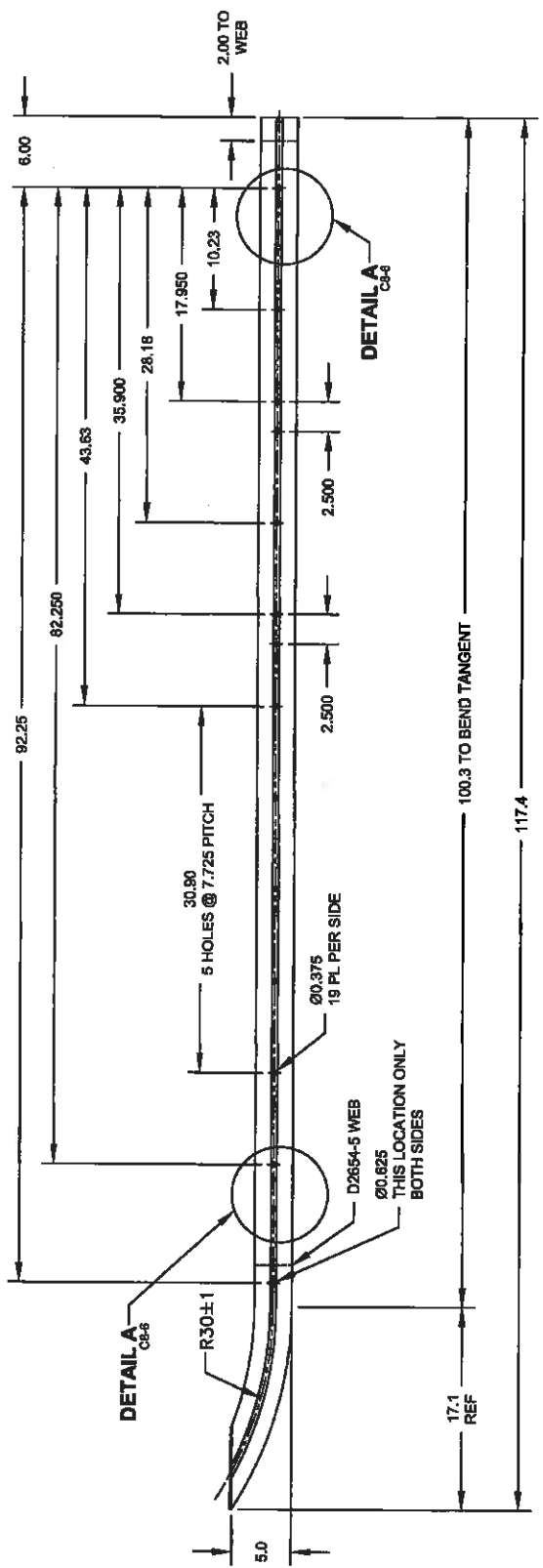
**D2650-3 BENDING/DRILLING DETAIL**



|            |          |                             |
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| MFG. APPR. | D2650    | DRAWING NO.                 |
| APPROVED   |          | REV. F                      |
| DE APPR.   |          | SHEET 3 OF 6                |
| DATE       | 08.08.08 | TITLE                       |
|            |          | 206/407 SKIDTUBE ASSEMBLIES |
|            |          | SCALE                       |
|            |          | NTS                         |

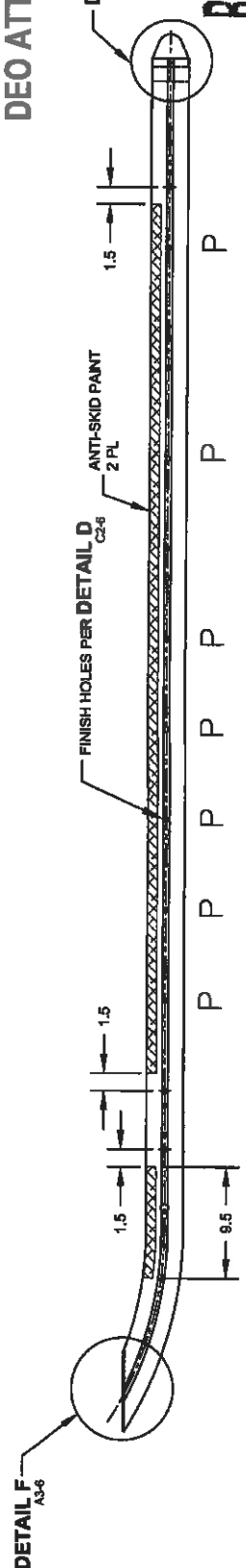
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1 2 3 4 5 6 7 8



D2650-5 BENDING/DRILLING DETAIL

DEO ATTACHED

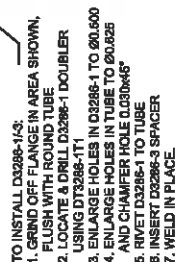


D2650-5 ASSEMBLY/FINISHING DETAIL

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R 105-019-117-1

|            |          |                                                                                      |
|------------|----------|--------------------------------------------------------------------------------------|
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| DRAWN      | AJS      | PORT HADLOCK, WA                                                                     |
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| MFG. APPR. |          | REV. F                                                                               |
| APPROVED   |          | SHEET 4 OF 6                                                                         |
| DE APPR.   |          | SCALE                                                                                |
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|            |          | UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES                             |





**DETAIL F NOTES:**

1. CUT TUBE LEVEL
  2. REMOVE RIDGE ON FWD SIDE
  3. LOCATE D2647 (TRIM AS NECESSARY)
  4. WELD D2647 IN PLACE PER DART QSI 004
  5. GRIND FLUSH
  6. RIVET D2680-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D2680-041 PRIOR

**NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH**

RELEASED

**DEO ATTACHED**

|            |          |                                                                                                                                                                                                                                                              |              |     |
|------------|----------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|-----|
| DESIGN     | DS       | DART AEROSPACE USA, INC                                                                                                                                                                                                                                      |              |     |
| DRAWN      | AJS      | PORT HADLOCK, WA                                                                                                                                                                                                                                             |              |     |
| CHECKED    |          | DRAWING NO.                                                                                                                                                                                                                                                  | REV. F       |     |
| MFG. APPR. |          | D2650                                                                                                                                                                                                                                                        | SHEET 6 OF 8 |     |
| APPROVED   |          | TITLE                                                                                                                                                                                                                                                        | SCALE        | NTS |
| DE APPR.   |          | 206/407 SKIDTUBE ASSEMBLES                                                                                                                                                                                                                                   |              |     |
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|                      |                                      |                  |                                         |                  |                         |                           |              |
|----------------------|--------------------------------------|------------------|-----------------------------------------|------------------|-------------------------|---------------------------|--------------|
| DRAWING NO.<br>D2650 | TITLE<br>206/407 SKIDTUBE ASSEMBLIES | REV. F           | DART AEROSPACE LTD<br>ENGINEERING ORDER |                  | D.E.O. NO.<br>D2650-F-1 | SHEET NO.<br>SHEET 1 OF 1 | SCALE<br>NTS |
| DRAWN<br>12.10.12    | CHECKED<br>A.C.                      | DATE<br>12.10.12 | MFG. APPR.<br>A.C.                      | APPROVED<br>A.C. | DE APPR.<br>A.C.        | DATE<br>12.10.12          |              |

**PURPOSE:**

CHANGE C'BORED WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

**CHANGE:**

PARTS LIST IS AMENDED AS FOLLOWS:

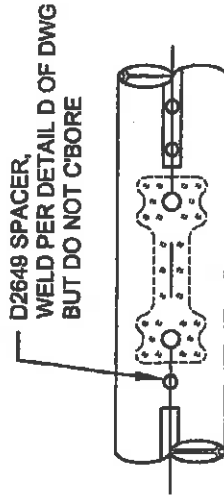
IS:

| QTY | QTY | QTY | QTY | DESCRIPTION       |
|-----|-----|-----|-----|-------------------|
| -1  | -3  | -5  | -7  |                   |
| 1   | 1   | 0   | 0   | CROSS BOLT SPACER |
| 16  | 17  | 19  | 23  | D4720-1 SPACER    |

WAS:

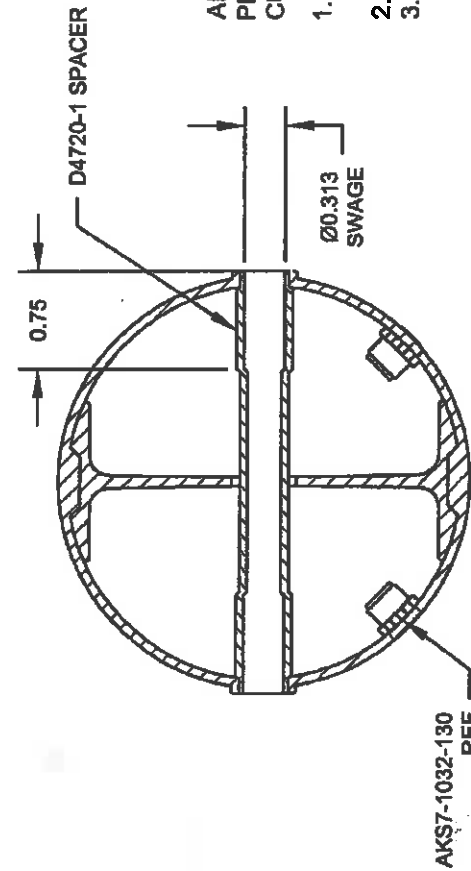
|    |    |    |    |       |                   |
|----|----|----|----|-------|-------------------|
| 17 | 18 | 19 | 23 | D2649 | CROSS BOLT SPACER |
|----|----|----|----|-------|-------------------|

ADD DETAIL G BELOW, WHICH IS THE SAME SECTION VIEW AS DETAIL D OF DWG. C'BORED HOLES ARE NOW SWAGED PER DETAIL G BELOW. FOR THE Ø0.375 HOLE THAT IS NOT C'BORED, WELD PER DETAIL D OF DWG (SEE AMENDED DETAIL B FOR REFERENCE).



**DETAIL B**

AMENDMENT TO DETAIL B  
NOT TO SCALE



**DETAIL G**

FOR Ø0.375 HOLES ONLY  
FOR HOLES THAT ARE CURRENTLY C'BORED ONLY  
NOT TO SCALE

AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.375 HOLES THAT ARE  
CURRENTLY C'BORED:

1. INSERT D4720-1 SPACER, 16 PL (-1) OR 17 PL (-3)  
OR 19 PL (-5) OR 23 PL (-7)
2. SWAGE TO Ø0.313 X 0.75 DP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

**RELEASED**  
2012-11-16